

Date: Thursday, 23/10/2008 10:54:10 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	206/OH-58 SADDLE, INBOARD, RIGHT SIDE - UNDER REVIEW
<b>Job Number</b> :	42888	<b>Part Number</b> :	D29381UP
<b>Estimate Number</b> :	12926	<b>Drawing Number</b> :	D2938 REV C
<b>P.O. Number</b> :		<b>Project Number</b> :	N/A
<b>This Issue</b> :	23/10/2008	<b>Drawing Revision</b> :	C
<b>Prsht Rev.</b> :	NC	<b>Material</b> :	
<b>First Issue</b> :	1/1	<b>Due Date</b> :	15/11/2008
<b>Previous Run</b> :	41723	<b>Qty:</b>	10
<b>Written By</b> :		<b>Um:</b>	Each
<b>Checked &amp; Approved By</b> :	JUD 08-10-23		
<b>Comment</b> :	Est Rev:A New Issue 07-07-04 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101003	Saddle Billet, 7075
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)  
 Issue material from stock: 7075-T7351 (QQ-A-250/12)  
 Cut Size 2.0" x 6.25" X 7.88" Grain Along 7.88" Length  
 (D6101-003) Batch No: B34873

1 scrap

S.F. 08/10/29

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1  
 Program part number and batch number.  
 1-Inspect part number and batch number are programmed correctly.  
 2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet  
 3-Machine Step No 2 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet  
 4-Machine Step No 3 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet  
 5-Deburr

DIP 08/10/30

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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**Comment:** CONVENTIONAL MILLING MACHINE  
 Machine Keyway and inspect per attached dimension sheet

DIP 08/11/08

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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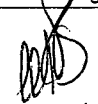
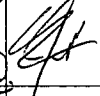
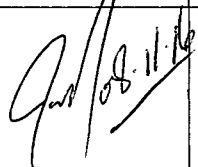
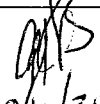


**Comment:** INSPECT ALL DIM TO DIM SHEET

DIP 08/10/30

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2938-1UP PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: 42888		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/10/29	# 8.1	First Run of D2935-1 has <del>is multiple</del> multiple problems. RC from switching from one	 08/10/30 08/10/42	SCRAP 08.10.29 ALL THICKNESS DIMS AFFECTED, TOO THIN. Destroy and Replace Qty 42	S.F. 08/10/29 	 08.11.29	 08/10/30 PS/42	 08/10/29
		HAS to another it was discarded that the offsets are not the same.		Bk <u>34873</u>				 08/10/29

NOTE: Date & initial all entries

Date: Thursday, 23/10/2008 10:54:10 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE - UNDER  
REVIEW

Job Number: 42888

Part Number: D29381UP

Job Number:



Seq. #: Machine Or Operation: Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 08/11/11

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M.H 08/11/11

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08-11-11 (X10)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: ST422

DS 08/11/12 (M)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/13

Job Completion



MF 08-11-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 42888
<b>Description:</b> 206 Saddle, Outboard, Left side	<b>Part Number:</b> D2938-1
<b>Inspection Dwg:</b> D2938 Rev. C	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.109	.110	0.116	0.119		
B	0.100	0.140		.106	.110	0.118	0.119		
C	0.100	0.140		.110	.115	0.118	0.120		
D	0.210	0.230		.218	.225	.224	.221		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.500	.510		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.313	.315	0.315	0.315		
M	0.235	0.240		.240	.239	.238	.235		
N	0.100	0.140		.106	.116	.111	.109		
O	0.540	0.560		.545	.553	0.555	0.555		
P	0.490	0.510		.500	0.500	0.500	0.500		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.743	2.744	2.744	2.744		
S	0.240	0.270		.240	.250	0.252	0.252		
T	0.100	0.180		.138	.140	0.130	0.130		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.370	1.370	1.370	1.370		
W	0.316	0.321		.316	.316	.316	.316		
X	1.250	1.270		1.262	1.269	1.266	1.2617		
Y	1.565	1.585		1.580	1.584	1.580	1.576		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <u>SP</u>
Date: <u>08/10/29</u>

Audited by: <u>J.L</u>
Date: <u>08/11/11</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 42888
<b>Description:</b> 206 Saddle, Outboard, Left side	<b>Part Number:</b> D2938-1
<b>Inspection Dwg:</b> D2938 Rev. C	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5	6	7	8	By	Date
A	0.100	0.140		0.119	0.116	0.116	0.117		
B	0.100	0.140		0.119	0.116	0.116	0.117		
C	0.100	0.140		0.119	0.120	0.120	0.118		
D	0.210	0.230		0.221	0.225	0.230	0.228		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	1.250	1.250	1.250		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		0.259	0.259	0.259	0.259		
L	0.312	0.317		0.315	0.315	0.315	0.315		
M	0.235	0.240		.238	.238	.238	.239		
N	0.100	0.140		0.110	0.113	0.114	0.114		
O	0.540	0.560		0.553	0.554	0.554	0.554		
P	0.490	0.510		0.500	0.500	0.500	0.500		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.744	2.744	2.740	2.740		
S	0.240	0.270		0.251	0.251	0.252	0.251		
T	0.100	0.180		0.135	0.130	0.130	0.130		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		0.318	0.318	0.318	0.318		
X	1.250	1.270		1.265	1.268	1.270	1.270		
Y	1.565	1.585		1.580	1.582	1.585	1.585		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: DJP
Date: 08/10/30

Audited by: JL
Date: 08/11/11

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



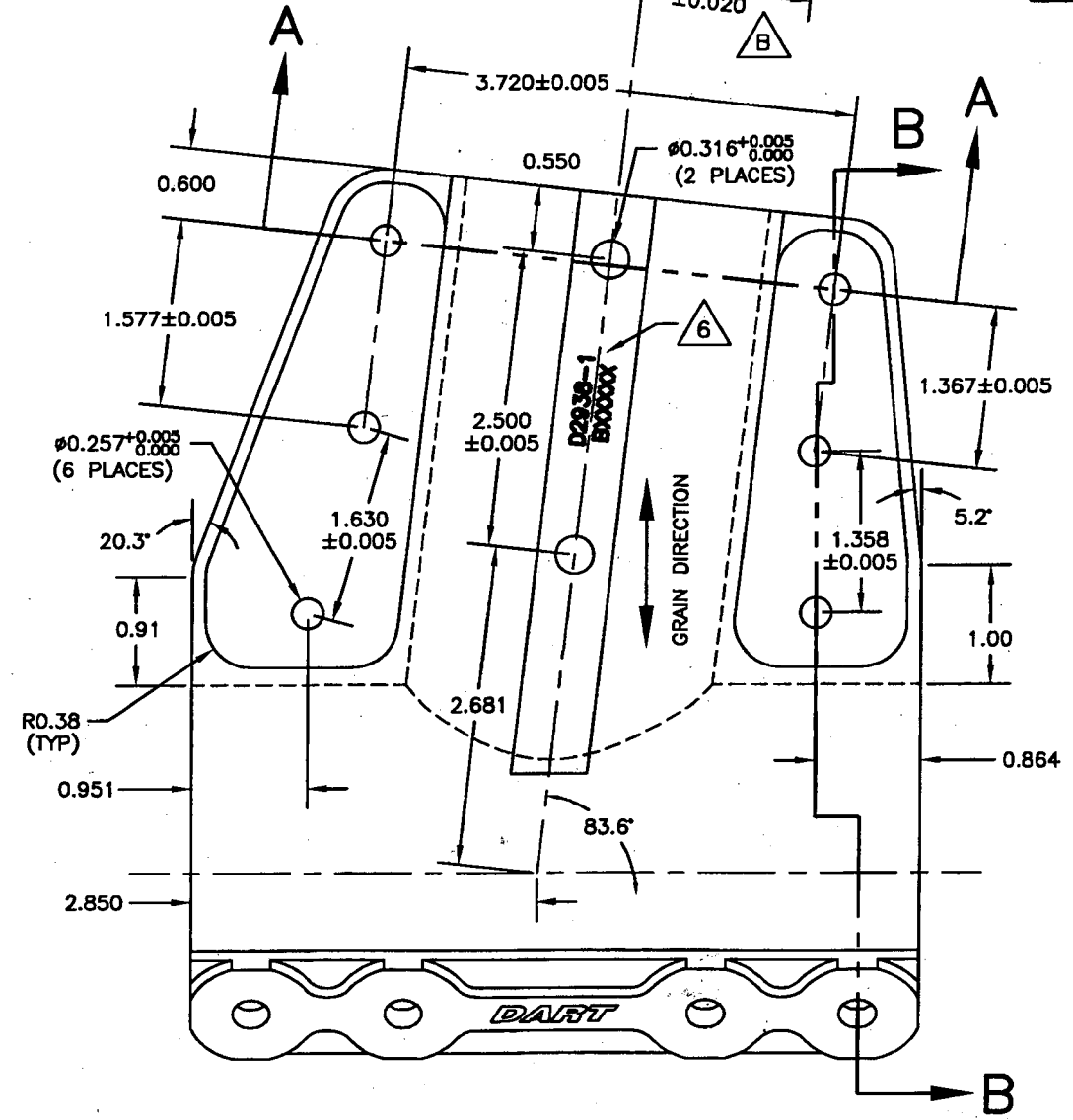
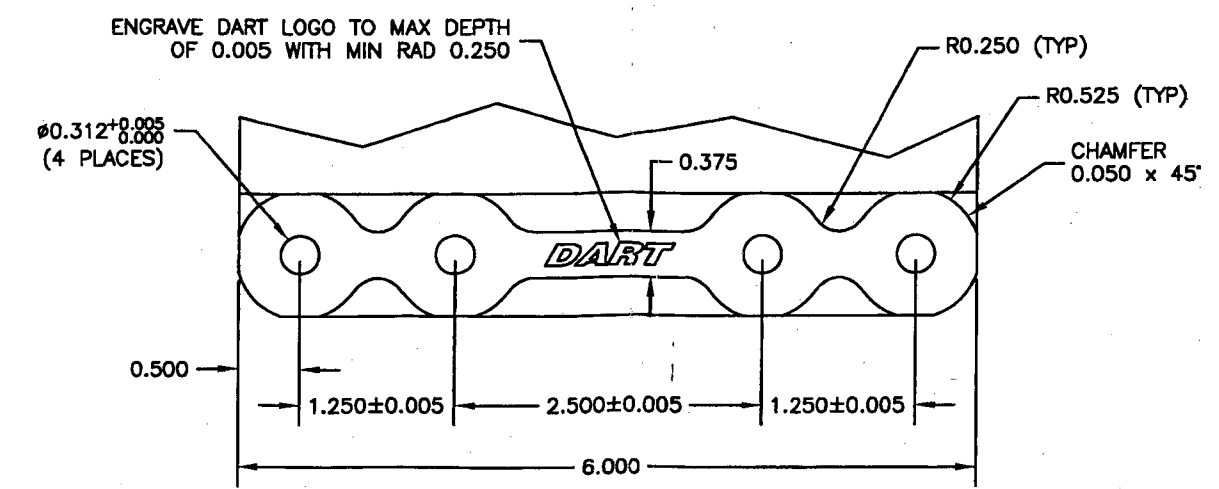
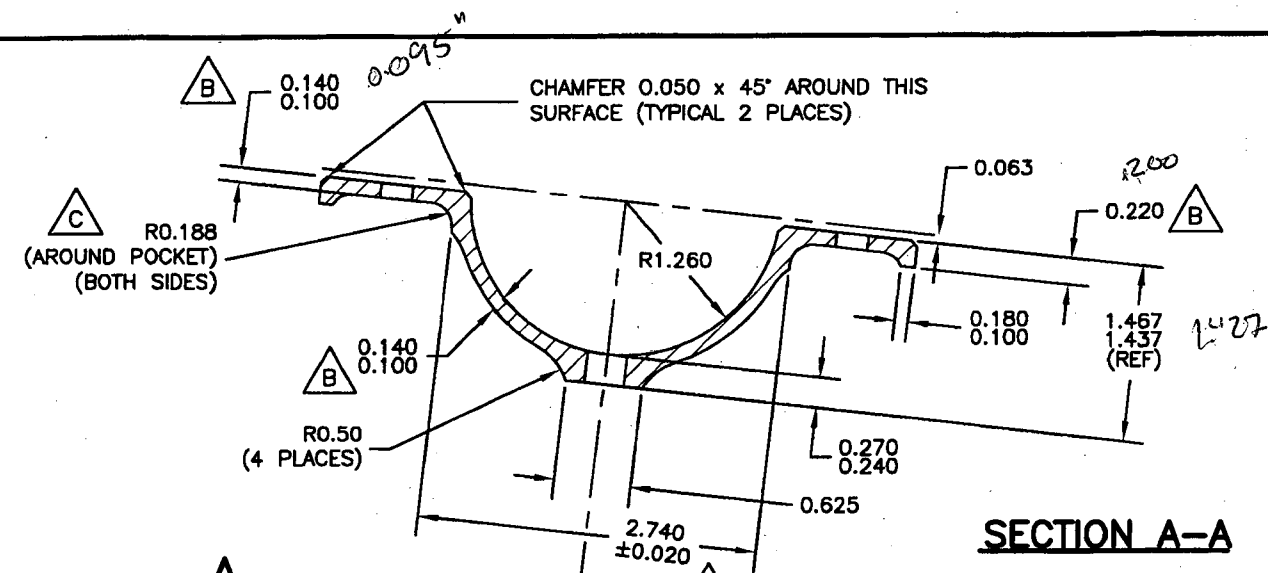
<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 42888
<b>Description:</b> 206 Saddle, Outboard, Left side	<b>Part Number:</b> D2938-1
<b>Inspection Dwg:</b> D2938 Rev. C	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

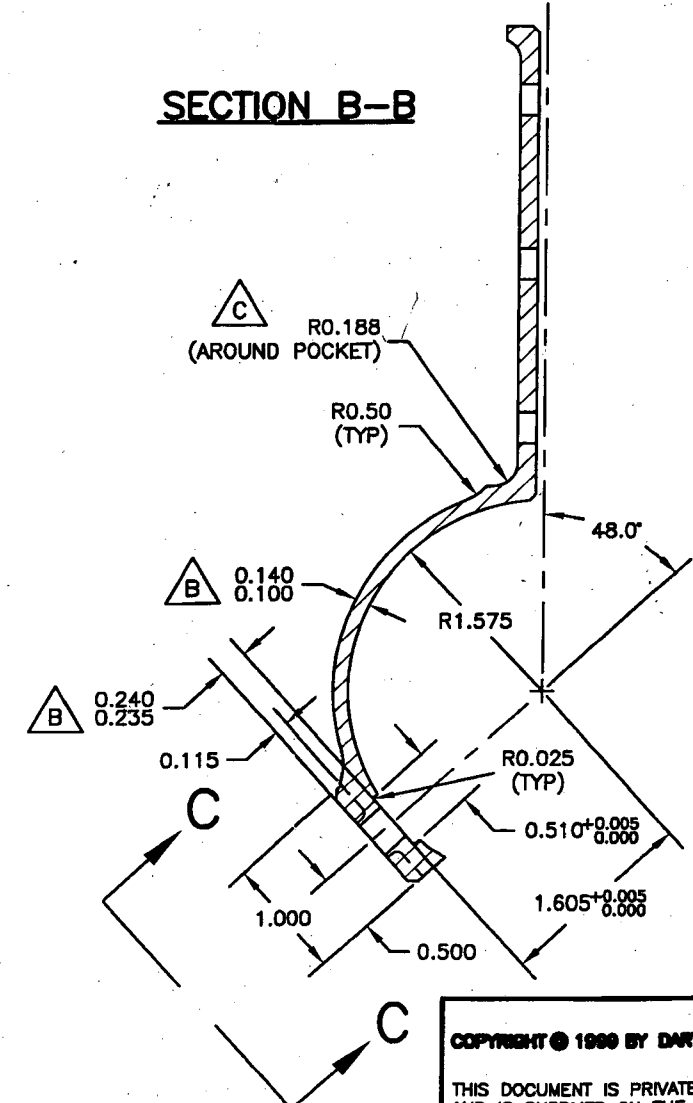
				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	9	10	3	4		
A	0.100	0.140		0.130	0.130				
B	0.100	0.140		0.130	0.130				
C	0.100	0.140		0.130	0.130				
D	0.210	0.230		0.228	0.228				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		0.510	0.510				
I	1.572	1.582		1.577	1.577				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262		0.259	0.259				
L	0.312	0.317		0.315	0.315				
M	0.235	0.240		0.238	0.238				
N	0.100	0.140		0.109	0.109				
O	0.540	0.560		0.552	0.553				
P	0.490	0.510		0.500	0.500				
Q	3.715	3.725		3.710	3.710				
R	2.720	2.760		2.740	2.740				
S	0.240	0.270		0.264	0.265				
T	0.100	0.180		0.130	0.130				
U	1.625	1.635		1.630	1.630				
V	1.362	1.372		1.367	1.367				
W	0.316	0.321		0.318	0.318				
X	1.250	1.270		1.2615	1.258				
Y	1.565	1.585		1.576	1.572				
Z	0.178	0.198		0.188	0.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: <u>DTP</u>	Audited by: <u>J.L</u>
Date: <u>08/10/30</u>	Date: <u>08/11/11</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	



**SECTION B-B**



**D2938-1 LH SADDLE (SHOWN)  
D2938-2 RH SADDLE (OPPOSITE)**

- NOTES:**
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12) (MAKE FROM D6101-003 SADDLE BILLET, 7075)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
  - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 5) ALL DIMENSIONS ARE IN INCHES
  - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 02888

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	DRAWN BY	<b>DART</b> DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	APPROVED	DRAWING NO. D2938 REV. C
DATE		SHEET 1 OF 1
06.11.09		TITLE SADDLE OUTSIDE SCALE 2:3

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RELEASED  
07.02.12

